

Split
Work Order ID 121957-2

121957

Monday, July 07, 2014 9:50:37 AM

Page 1

Item ID: D5062-041

Accept

Revision ID:

N900040100

Setup Start *NS1*

Item Name: Bracket Assembly

Stop *NS2*

Start Date: 7/07/14 Start Qty: 20.00

20

Required Date: 7/07/14 Req'd Qty: 20.00

20

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan: MJS

Date: 4-07-07

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D5062 | A | | | | | | | | |

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut D5062-1F as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr as required

0.00

0.00

DAS

46

9-89

14/08/05

24

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

46

9-89

14/08/05

24

Work Order ID 121957

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Page 2

Item ID: D5062-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 7/07/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 7/07/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|-------------------------------|--------------|---------------|---------------|------------------|------------------------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | DAS 38 9-89 14/08/05 | | (24) | | | |
| 130 *130* Brake NC Brake NC | Bend as per dwg Memo | 0.00 0.00 | | DAS 30 9-89 | | 10 | | | 14/08/20 |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | (10) | PD | | DAS 38 9-89 14-8-21 |

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Item ID: D5062-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket Assembly
Start Date: 7/07/14 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 7/07/14 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|-------------------|---------------|---------------|------------------|----------------|
| 150 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Hand Finish | Memo | 0.00 | | | | 10 | | 16/148-22 | |
| Hand Finishing | | | | | | | | | |
| 160 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | DAS 30 9-89 | 10 | | | 14/148/22 |
| Quality Control | | | | | | | | | |
| 170 | | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | INSTALL RIVET AS PER DWG | | | | | 10 | | FF 14-08-22 | |

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

Identify as per dwg & Stock Location: _____

0.00

Memo

57132

0.00

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

QC

Quality Control

MLJ 1409-03

Picklist Print

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Page 1

Work Order ID: 121957

Parent Item: D5062-041

Parent Item Name: Bracket Assembly

121957

D5062-041

Start Date: 7/07/14

Required Date: 7/07/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A 14.02.11 NEW ISSUE DD VERF:JLM
REV:B 14.05.28 AS PER DWG REV.A DD VERF:JLM

IPP

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6S.080

Purchased

No

sf

576.3760

4.210526

DAS

46

9-89

M6061T6S 080

6061-T6 .080 Sheet



Location

Loc Qty

Loc Code

MAT021

325.51

m126309

130.52

m126350

13.34

m128903

181.65

TPI

250.866

m129439

250.866

Each

2,807.000

80

**

FF 14-08-22

MS20470AD4-5

Purchased

No

MS20470AD4-5

RIVET, UNIVERSAL HEAD

Location

Loc Qty

Loc Code

ST312

2807

m126926

4

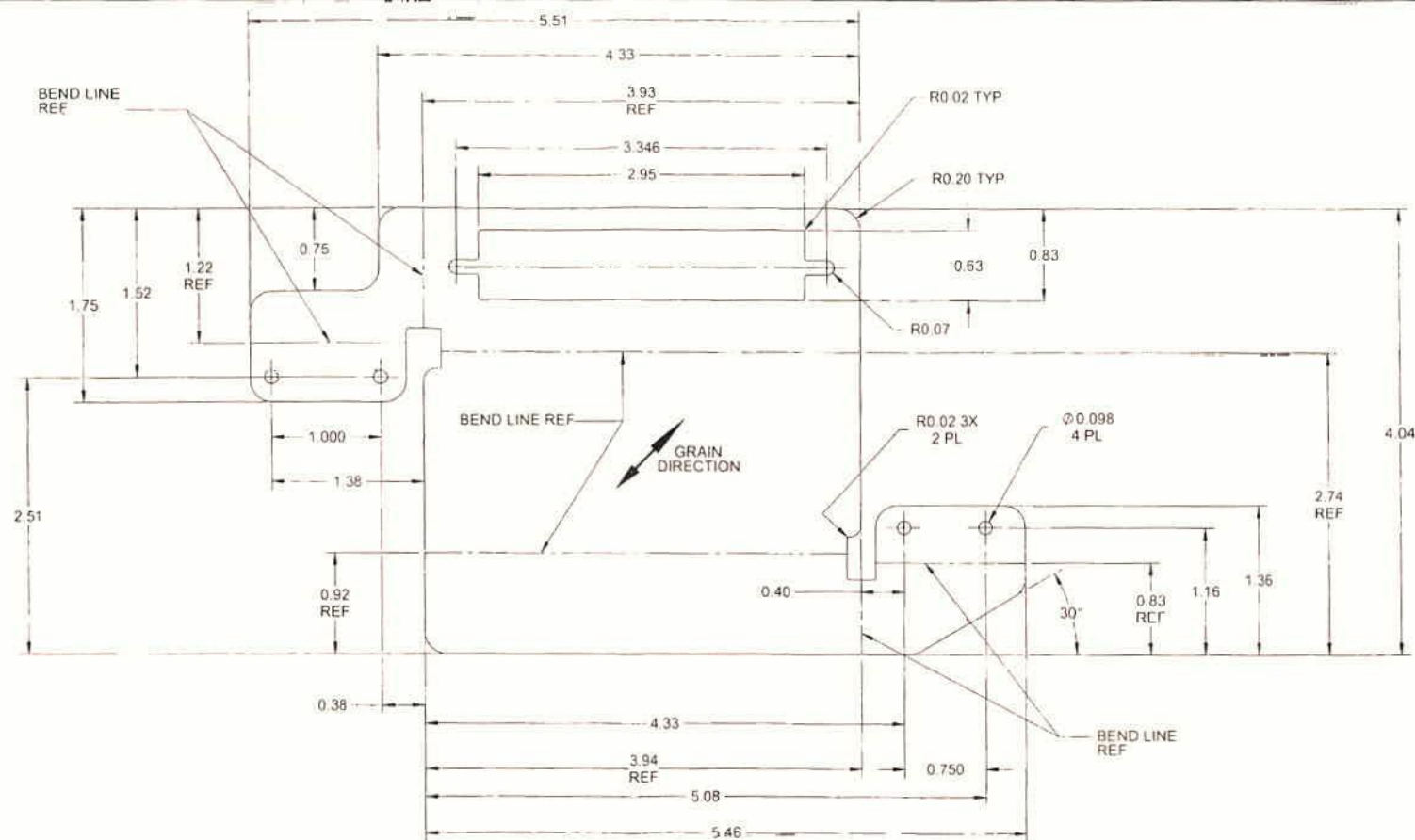
m128401

1653

m128813

1150

40



D5062-1F FLAT PATTERN

RELEASED
2014-05-28

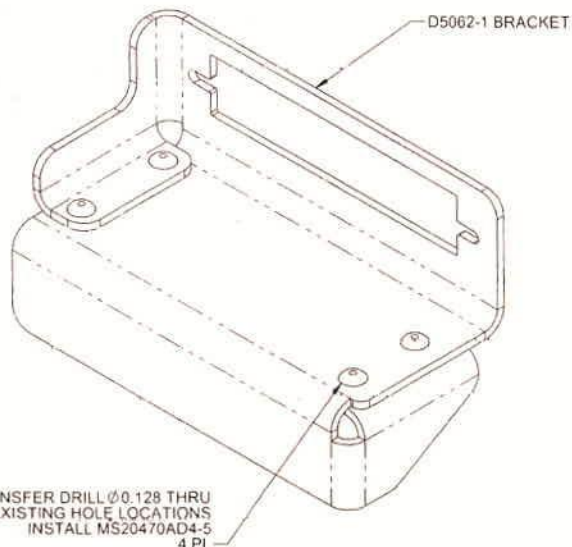
NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: D5062-1F: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5062-1F-A.DXF"

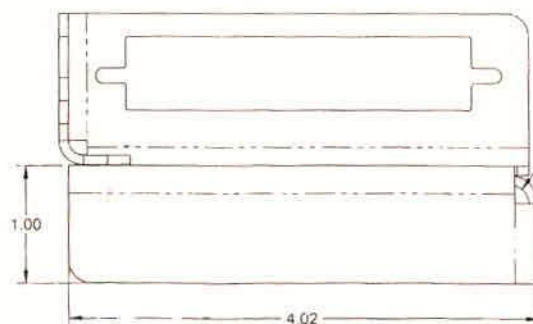
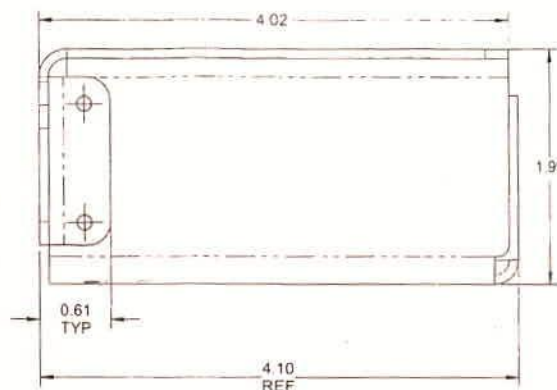
| | | | |
|------------|----------|--|--------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | DB | | |
| CHECKED | DW | DRAWING NO. | REV. A |
| MFG. APPR. | DD | D5062 | SHEET 2 OF 2 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | DS | # BRACKET | NTS |
| DATE | 14.02.10 | COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. HERE IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

| ITEM | QTY. | PIN | DESCRIPTION |
|------|------|--------------|----------------|
| | X | D5062-041 | BRACKET ASSY |
| 1 | 1 | D5062-1 | BRACKET |
| 2 | 4 | MS20470AD4-5 | RIVET, PANHEAD |

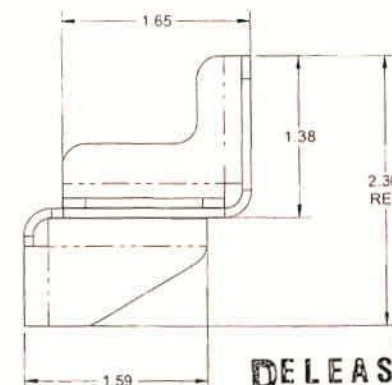
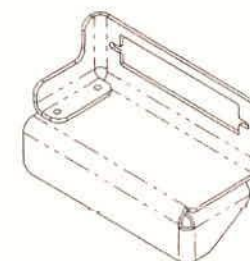
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK DELIVER
NO 121957 MJS
140707



D5062-041 BRACKET ASSY



D5062-1 BRACKET
MAKE FROM D5062-1F



RELEASED
2014-05-28

NOTES

- 1) MATERIAL: MAKE FROM D5062-1F
- 2) FINISH: D5062-1: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
D5062-041: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5062-041" PER QSI 044 6.1
- 7) WEIGHT: 0.13lbs

| | | | |
|-----------|-------------|----|----------|
| A | NEW ISSUE | DB | 14.02.10 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DB | | |
| DRAWN | DB | | |
| CHECKED | DW | | |
| MFG. APPR | DD | | |
| APPROVED | MP | | |
| DE APPR | DS | | |
| DATE | 14.02.10 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5062** REV. A
SHEET 1 OF 2
TITLE **BRACKET** SCALE NTS

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